

FIG. 1

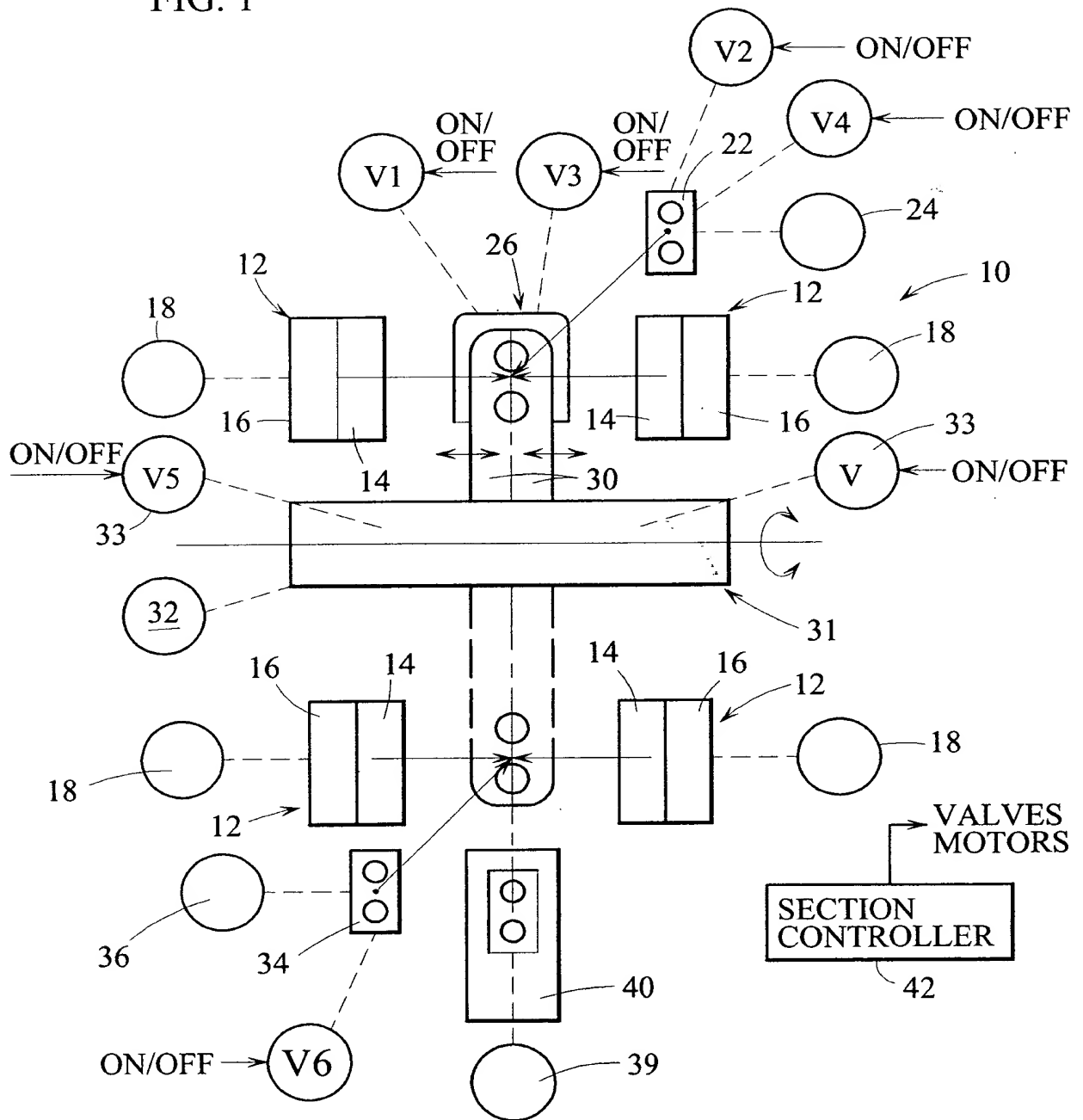


FIG. 2

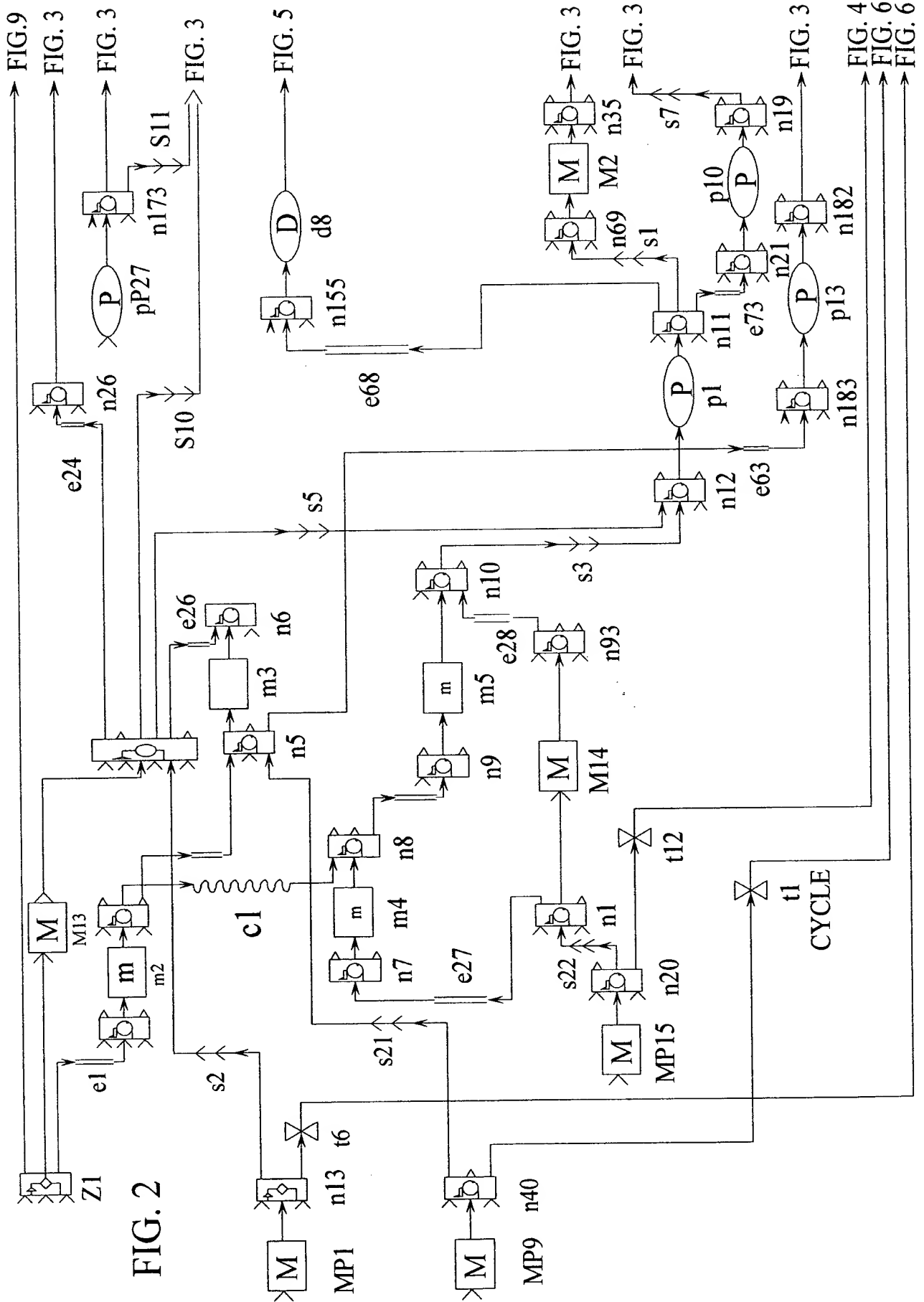
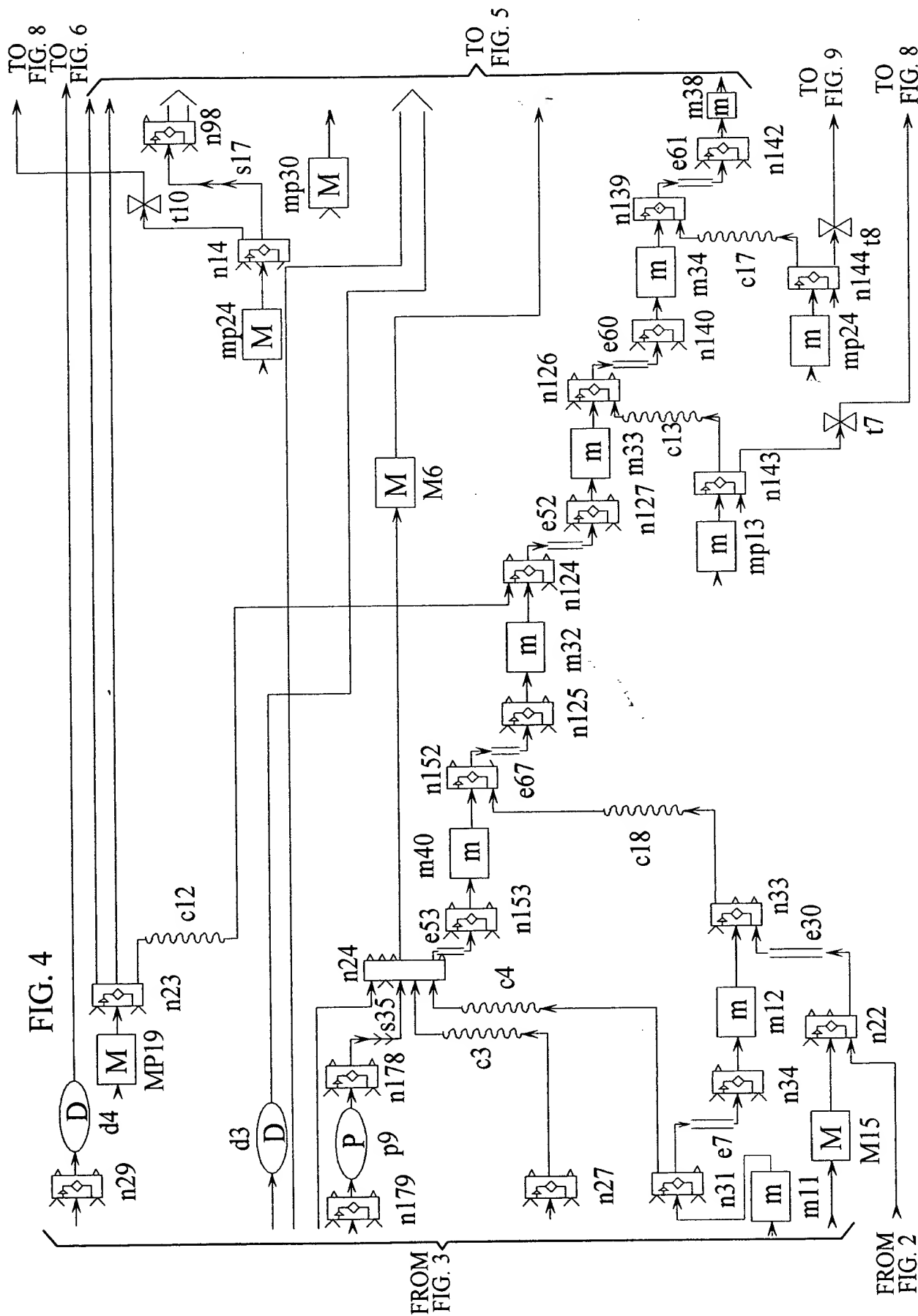




FIG. 4





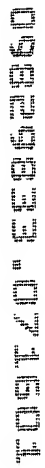
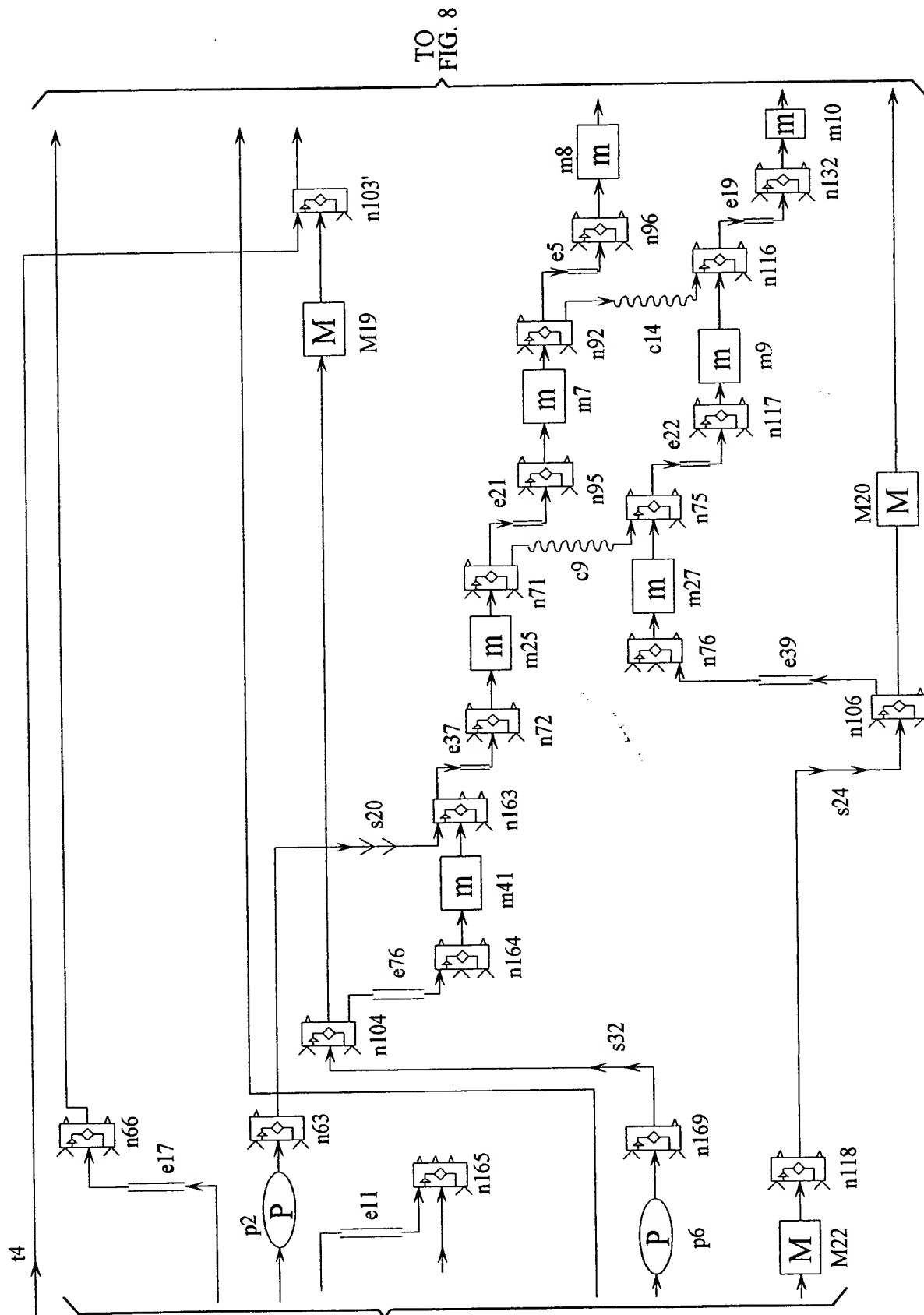


FIG. 7

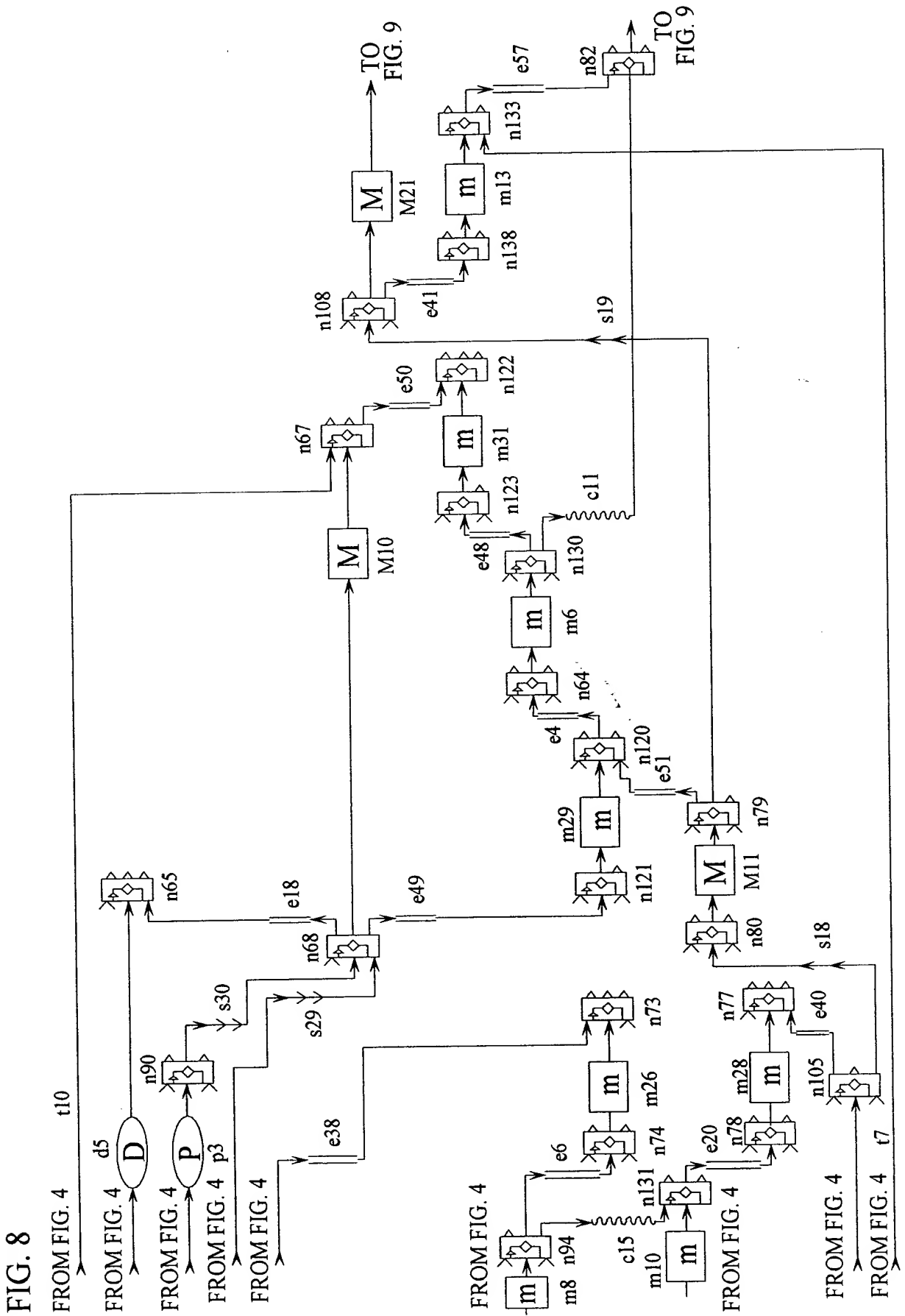
FIG. 7

FROM  
FIG. 5



TO  
FIG. 8

FIG. 8



FROM FIG. 2 →

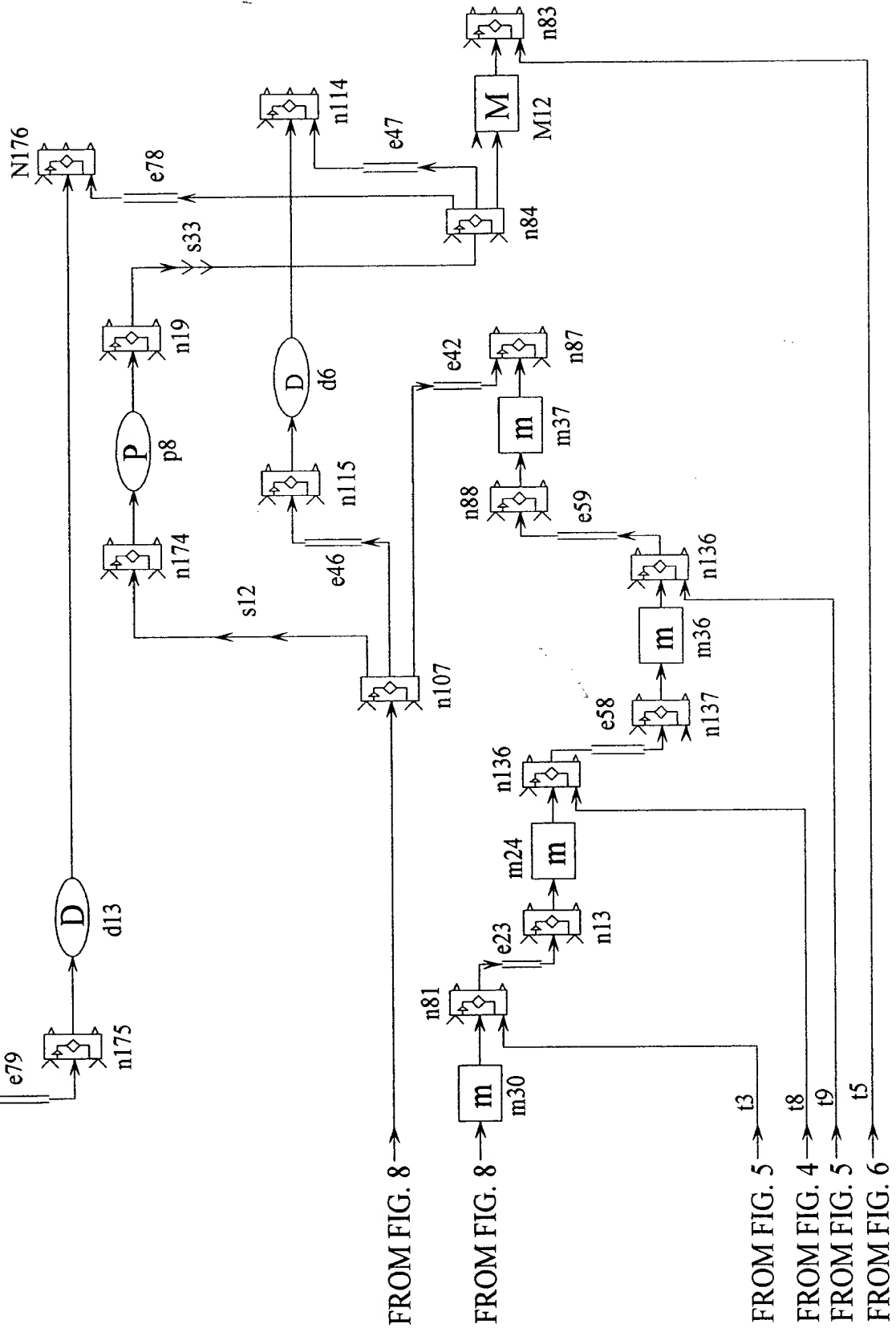


FIG. 10

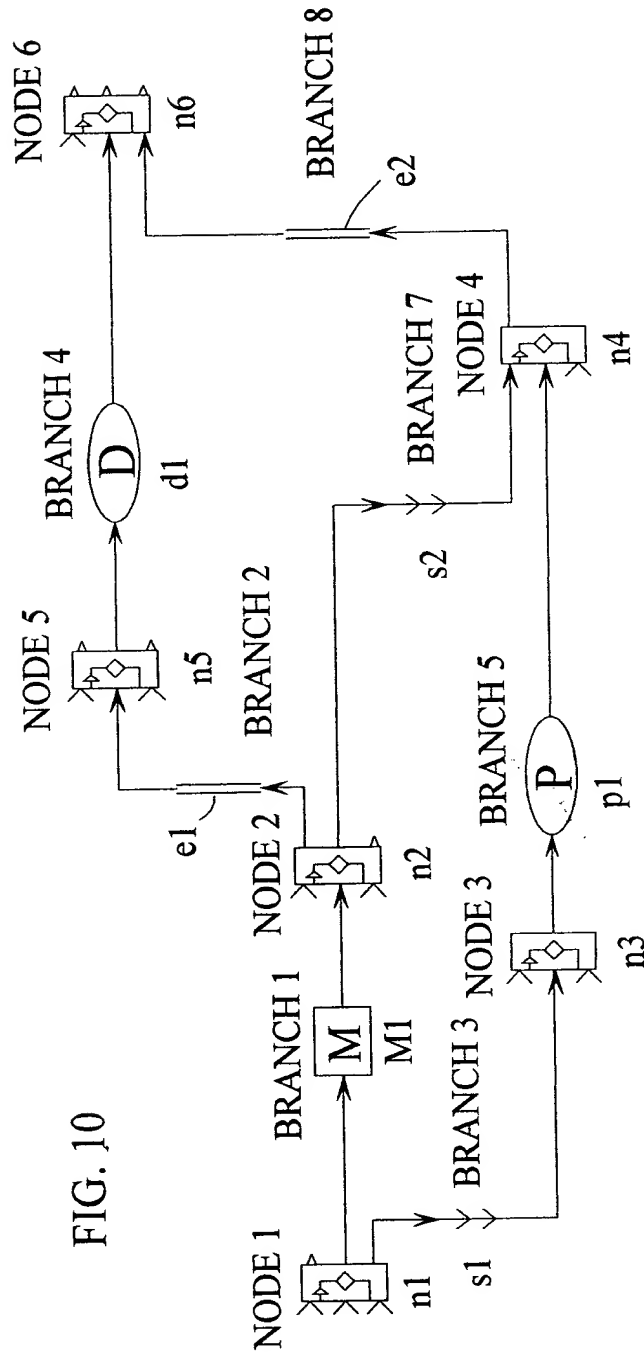


FIG. 11

|    |                  | G     | H   |
|----|------------------|-------|-----|
| 1  | EVENTS           | ON    | OFF |
| 2  | GOB INTERCEPTOR  | 334   | 14  |
| 3  | BLANKS CLOSE     | 324   | 130 |
| 4  | BLANKS OPEN      | 130   | 321 |
| 5  | PLUNGER UP       | 33    | 123 |
| 6  | FIRST BAFFLE     | 9     | 125 |
| 7  | PLUNGER DOWN     | 127   | 327 |
| 8  | FUNNEL           | 1     | 150 |
| 9  | SETTLE BLOW      | 1     | 1   |
| 10 | PLUNGER COOLING  | 150   | 260 |
| 11 | INVERT           | 200   | 260 |
| 12 | NECKRING OPEN    | 274.5 | 283 |
| 13 | REVERT           | 282   | 172 |
| 14 | MOLDS CLOSE/OPEN | 229   | 170 |
| 15 | MOLD COOLING     | 10    | 150 |
| 16 | FLOWHEAD         | 290   | 113 |
| 17 | FINAL BLOW       | 348   | 120 |
| 18 | TAKE OUT IN      | 137   | 197 |
| 19 | TONGS CLOSE      | 178   | 78  |
| 20 | TAKE OUT OUT     | 197   | 90  |

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FIG. 12A

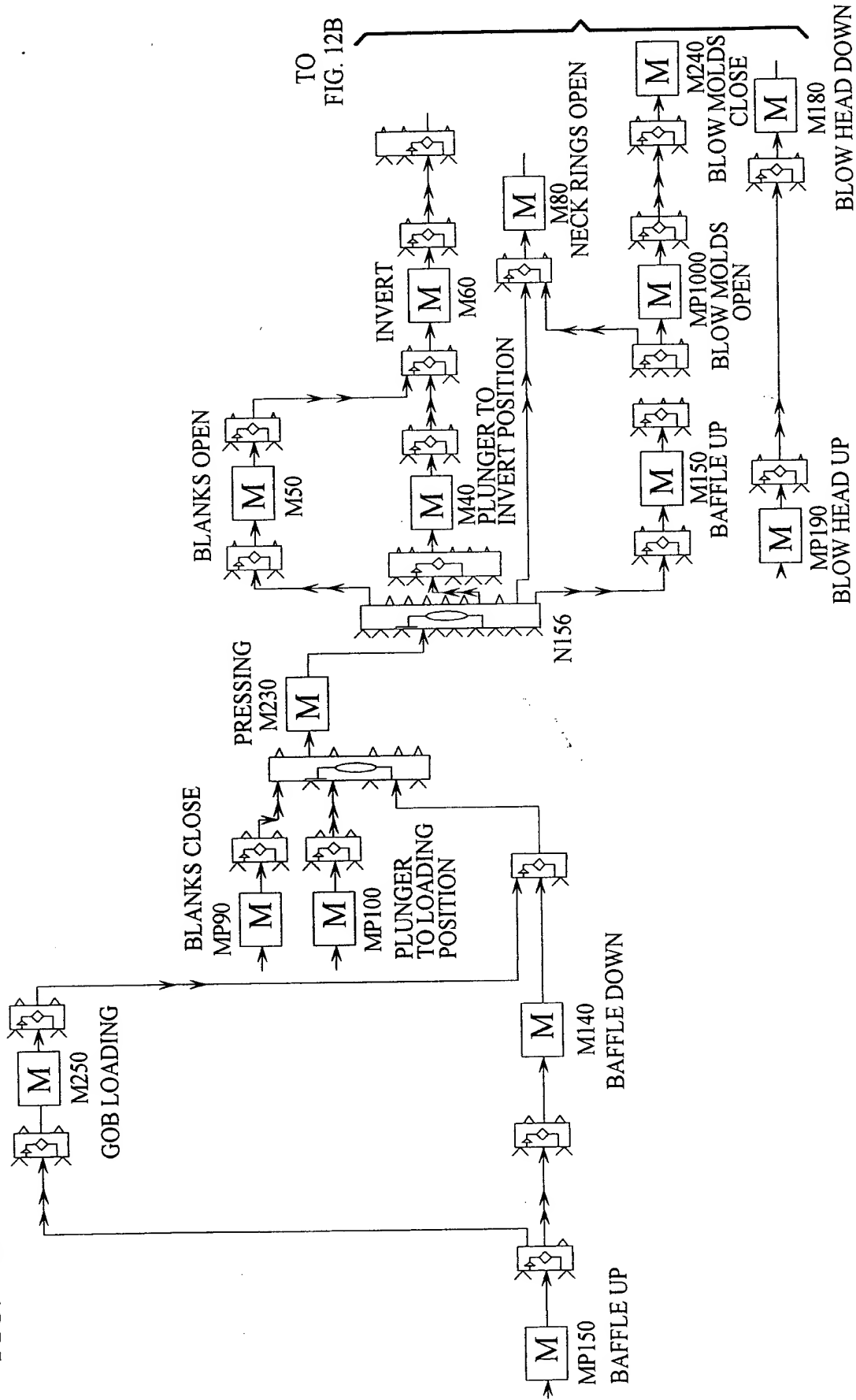


FIG. 12B

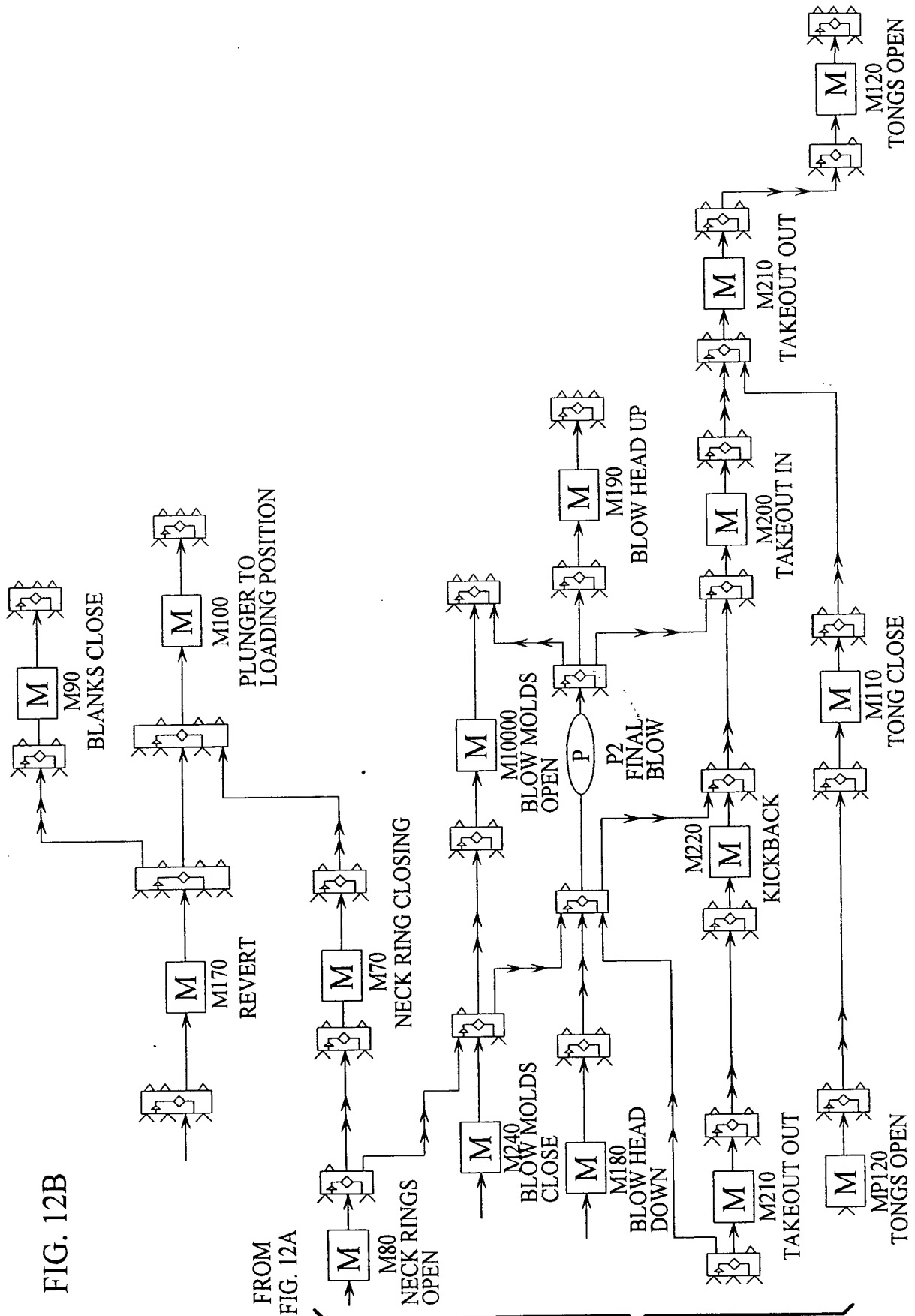


FIG. 13

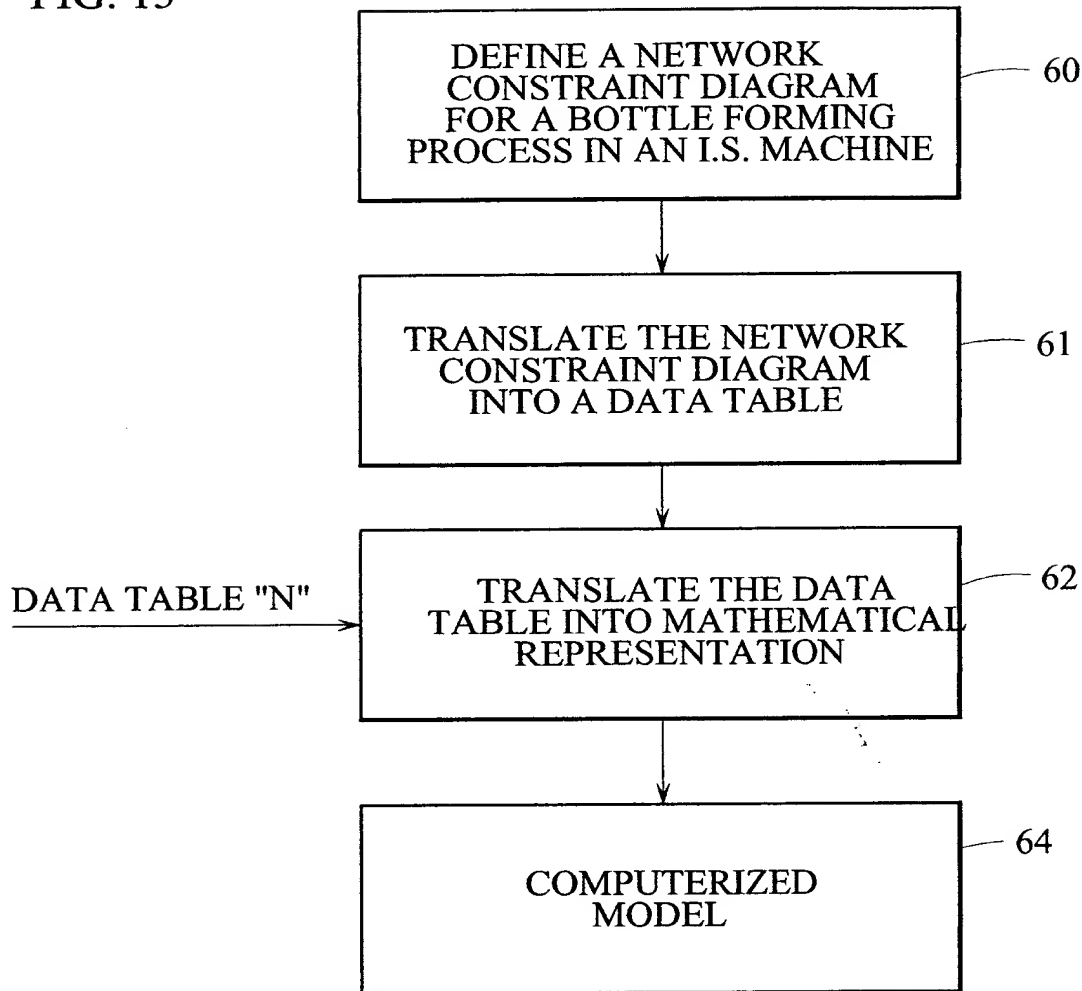


FIG. 14

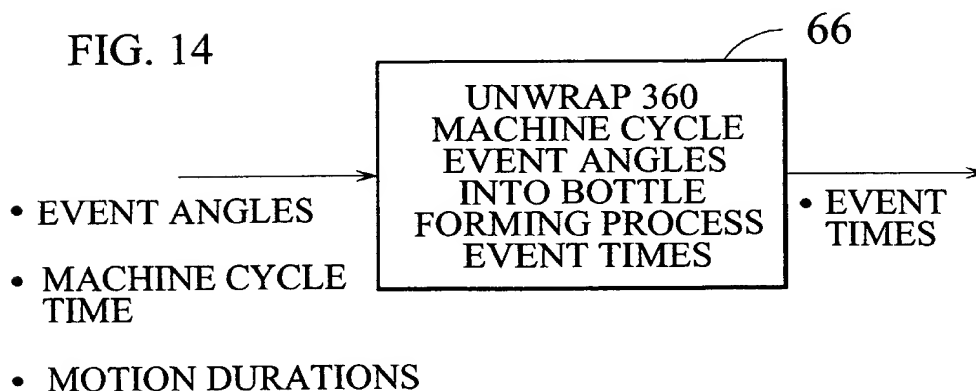


FIG. 15

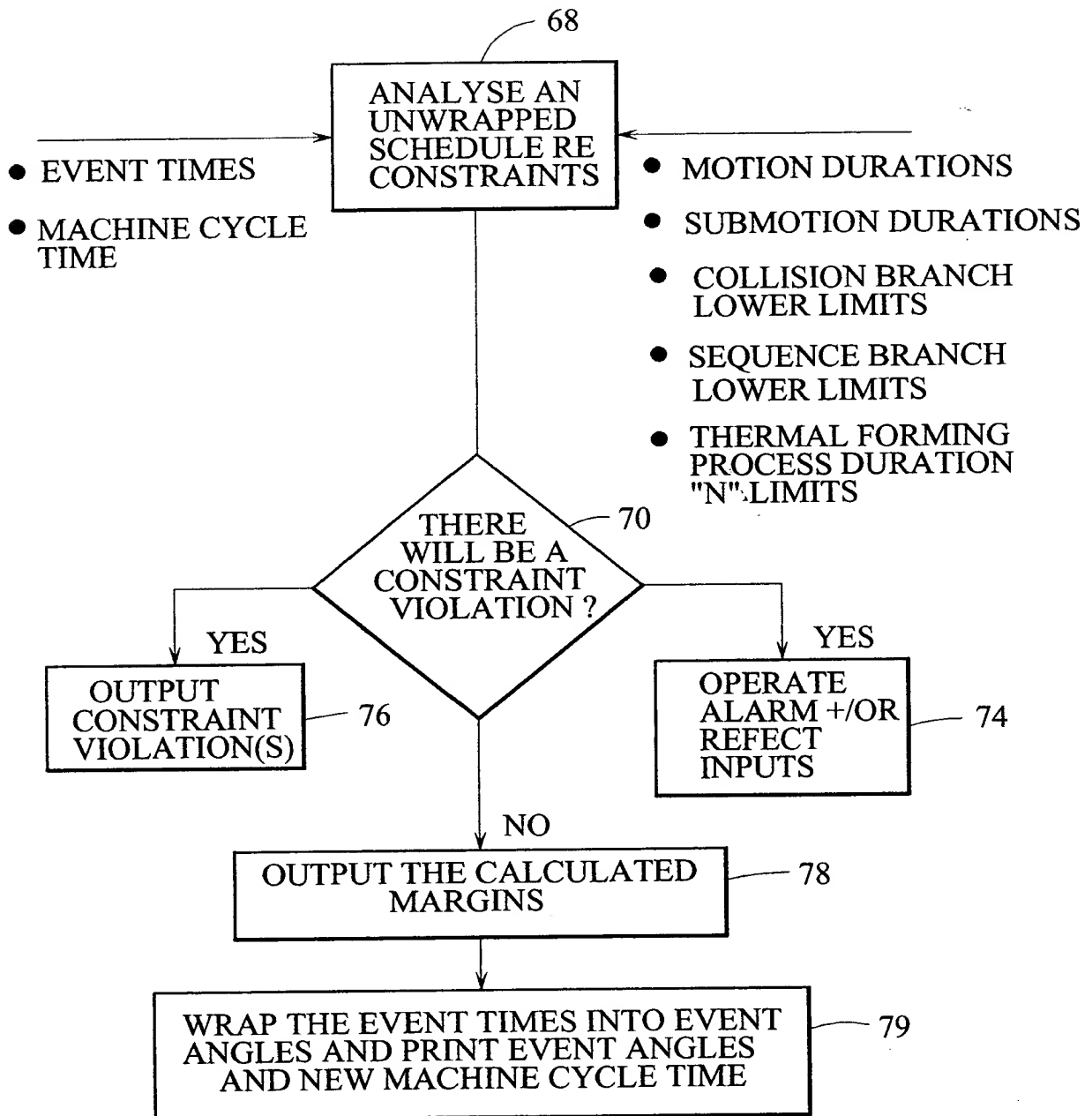
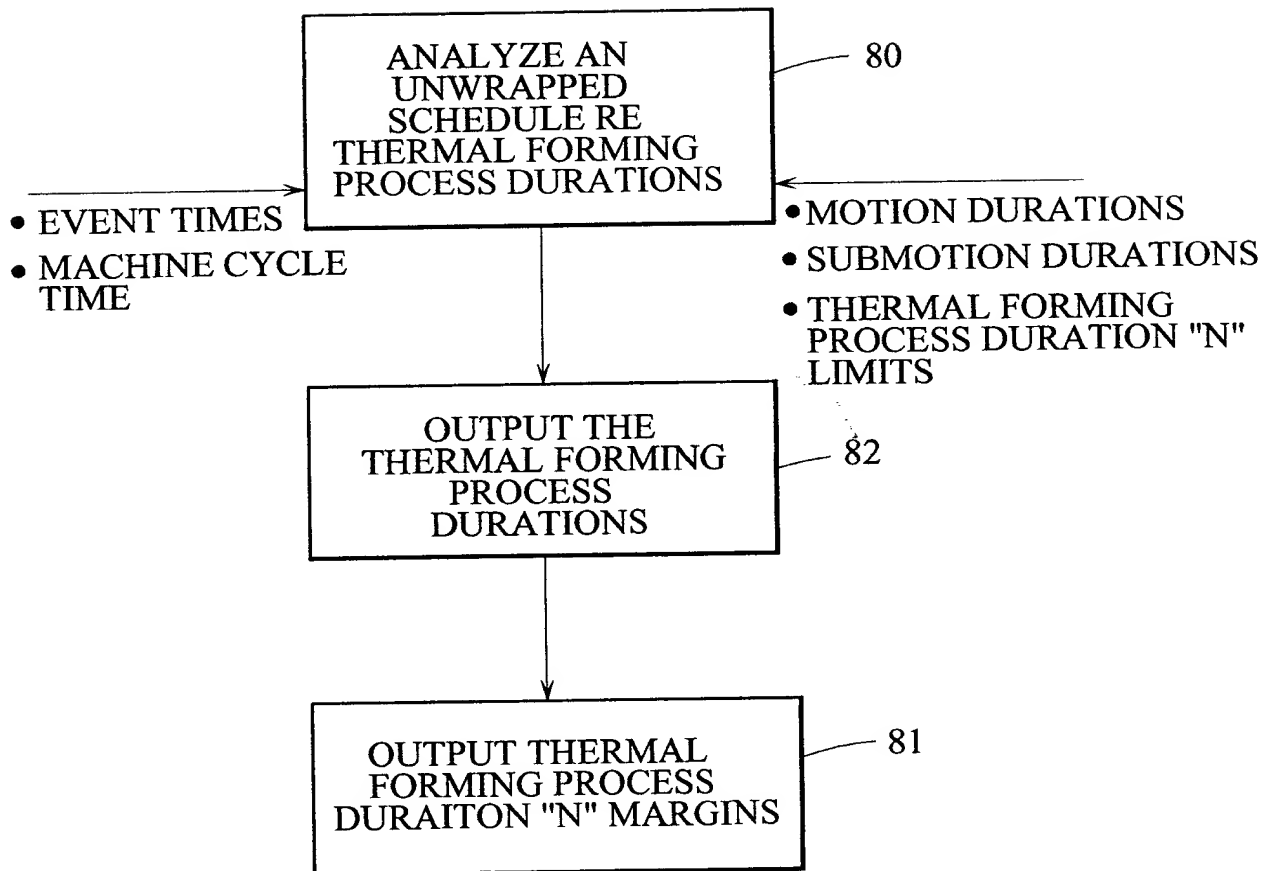


FIG. 16



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FIG. 17

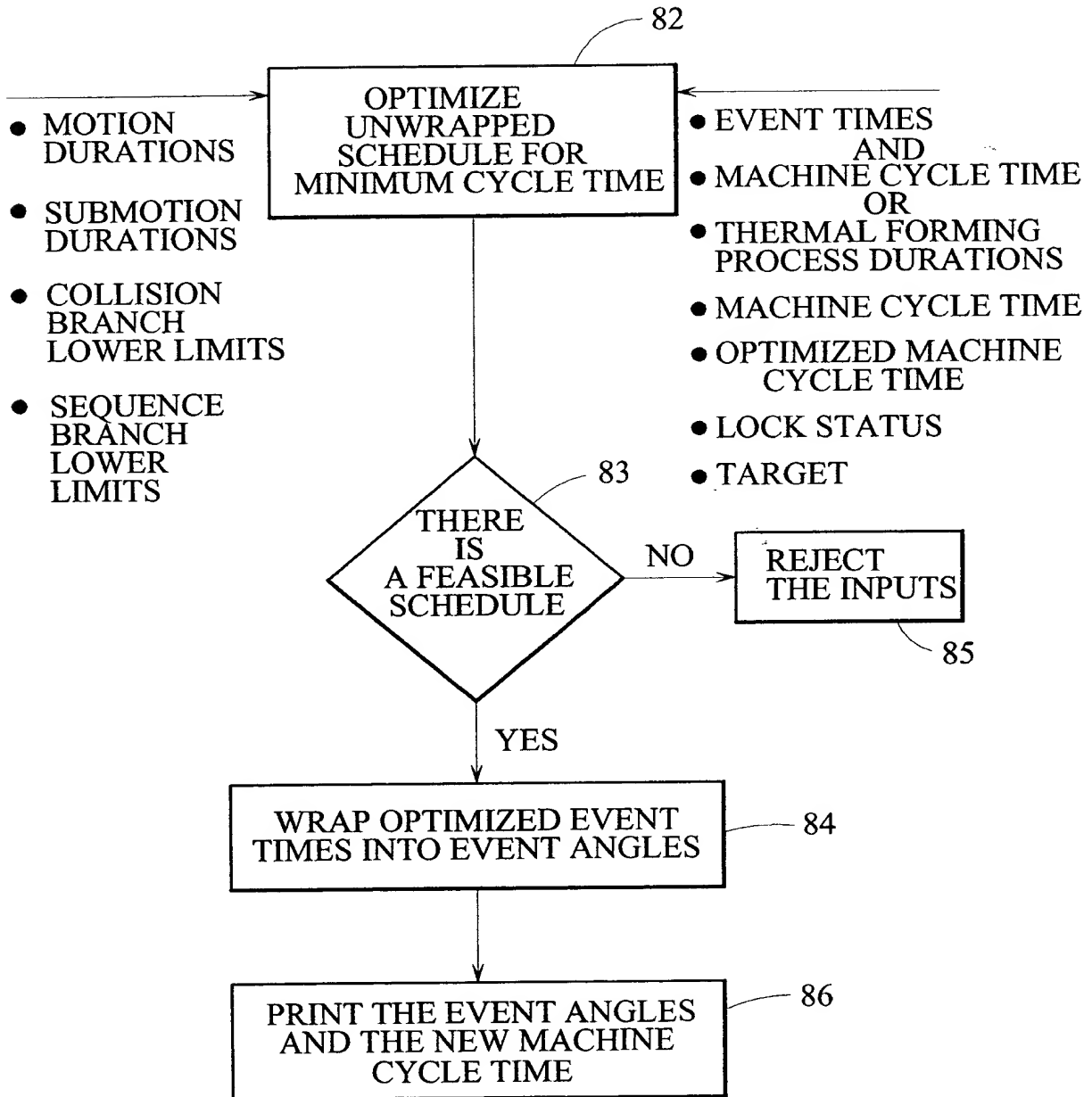


FIG. 18

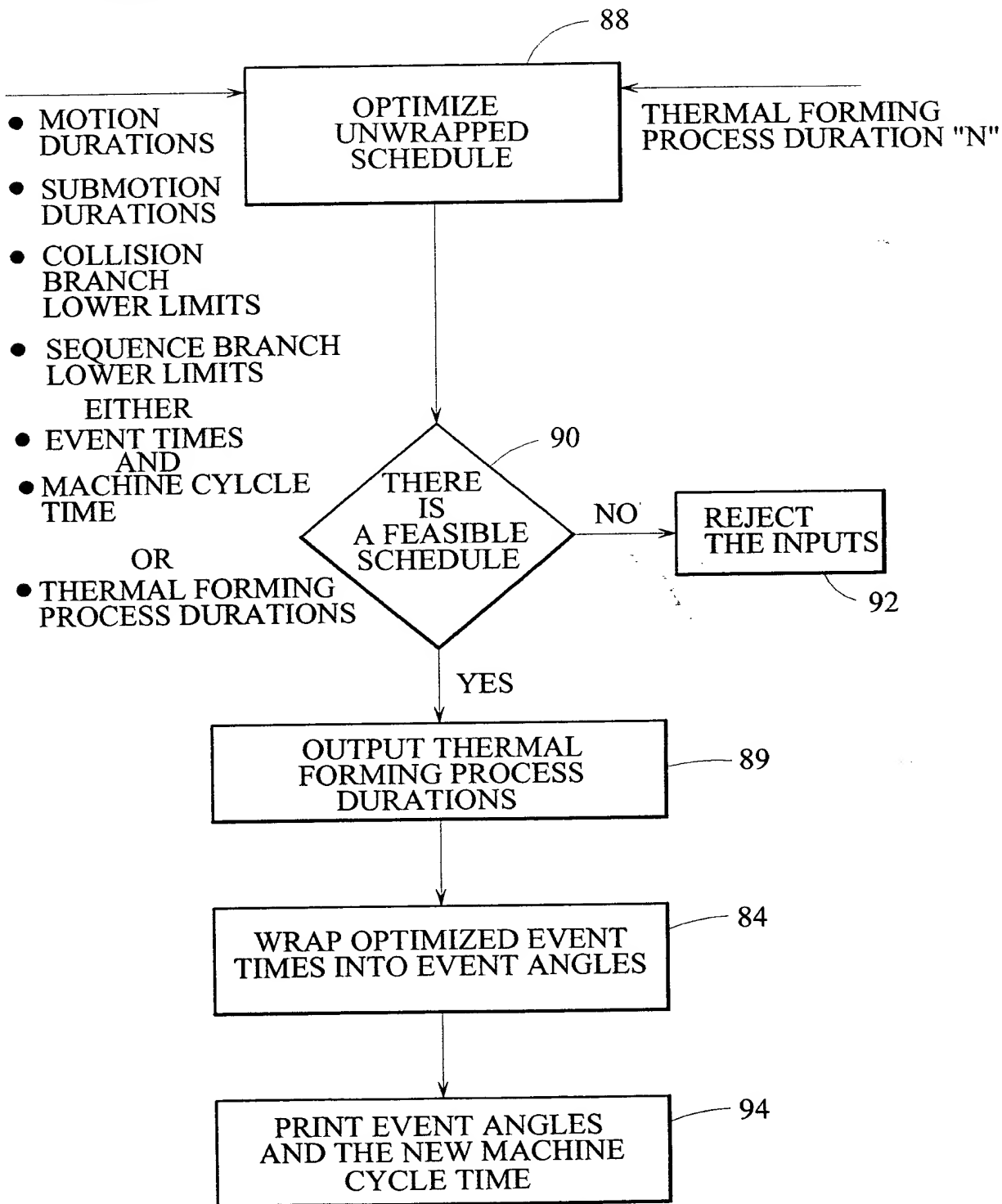


FIG. 19

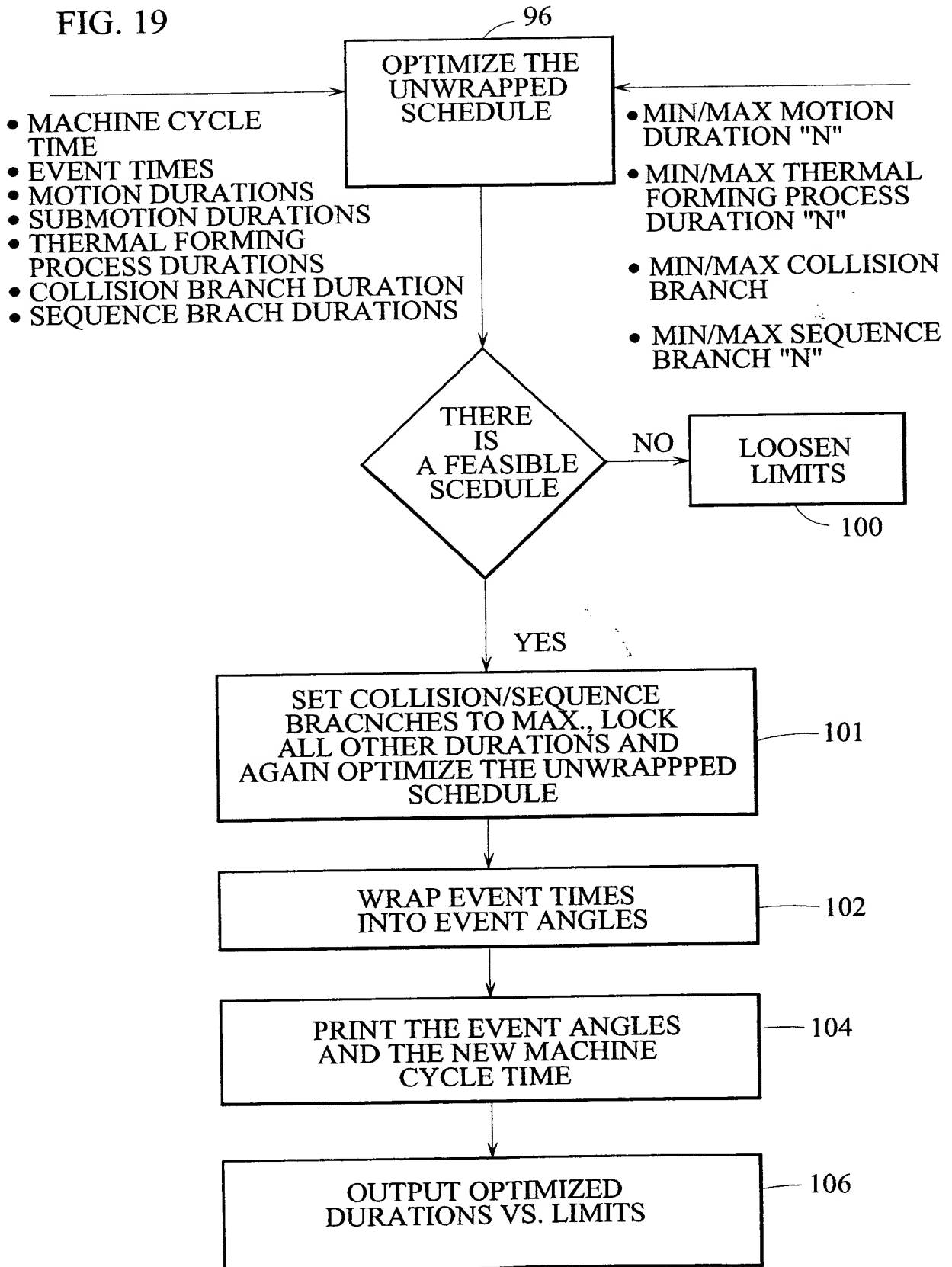
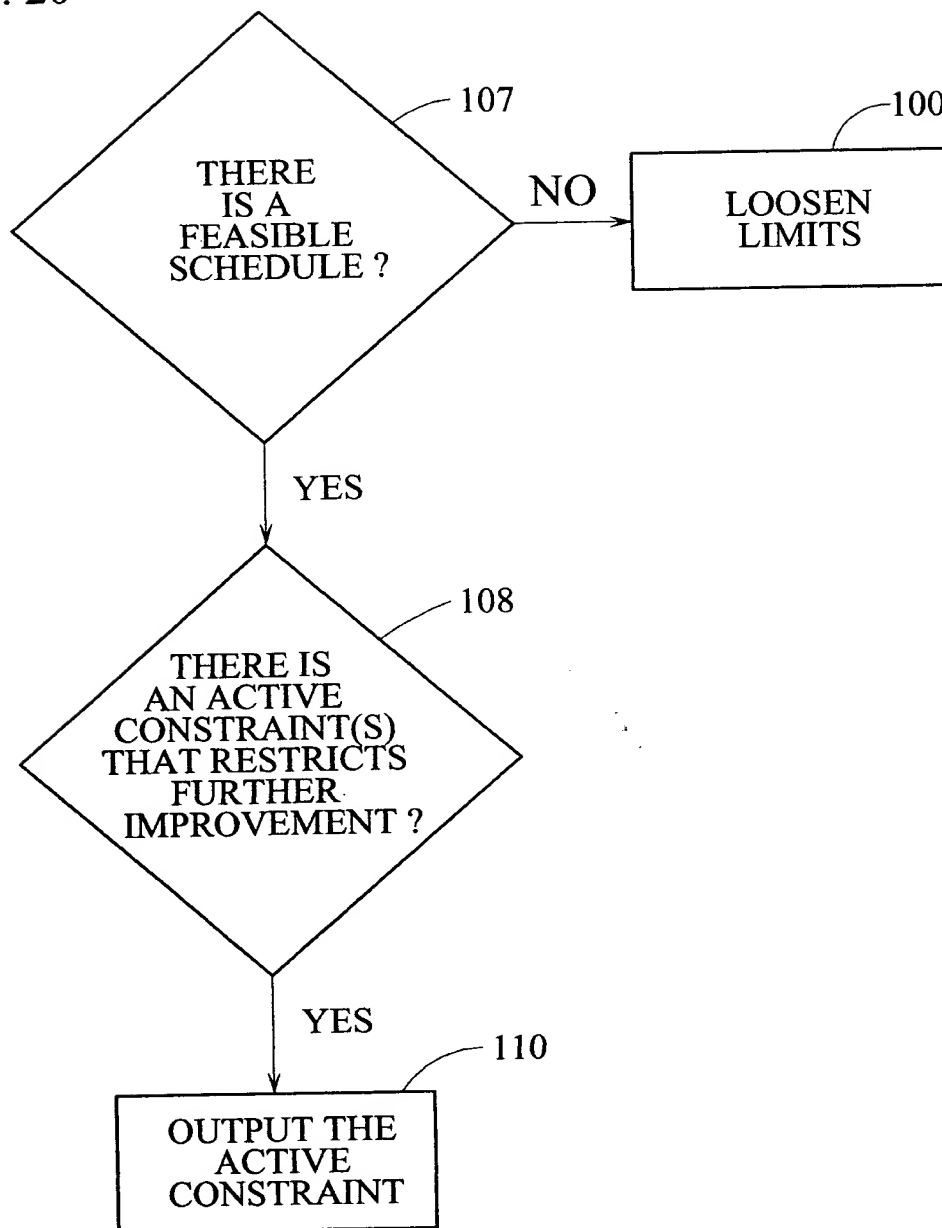
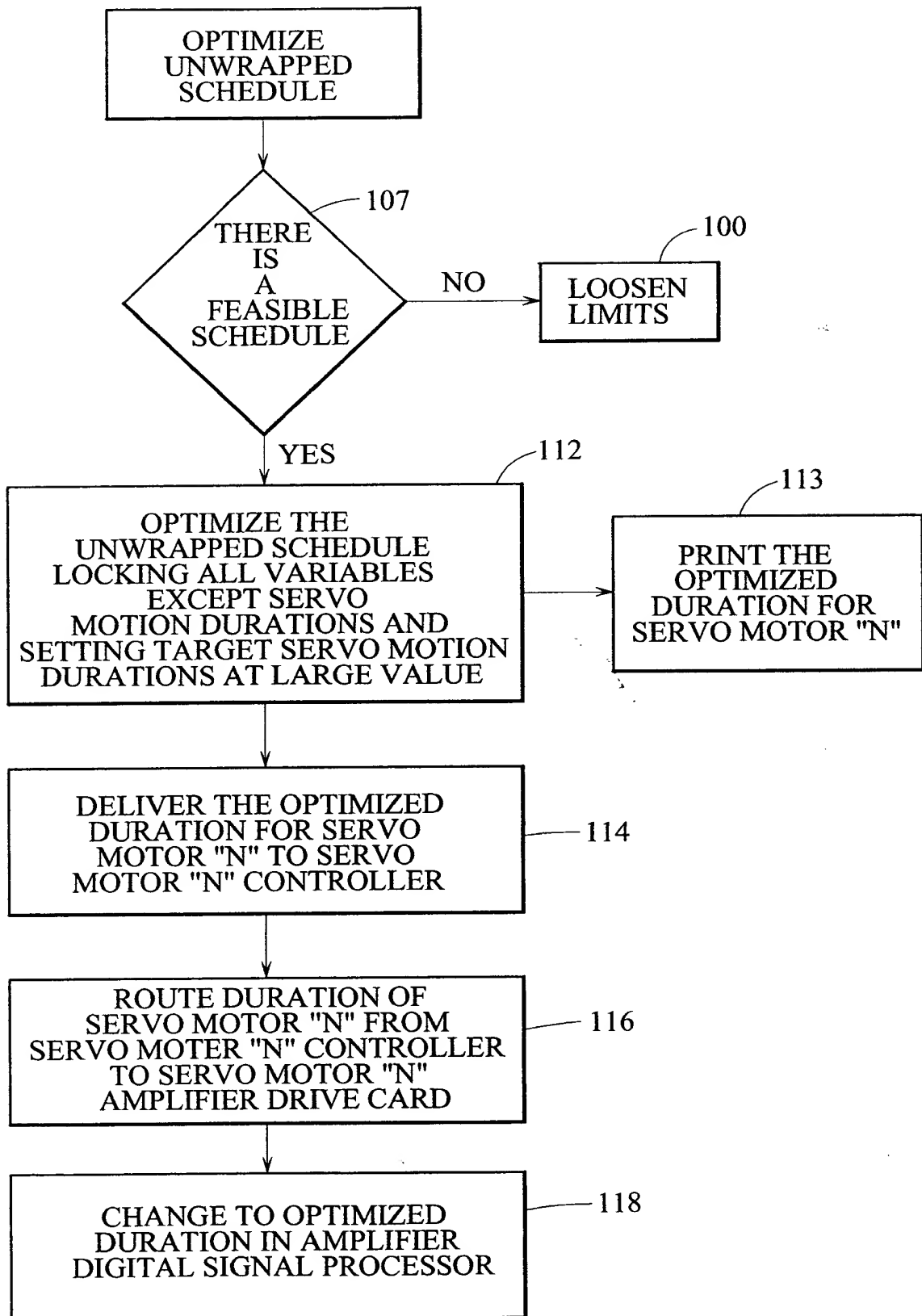


FIG. 20



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FIG. 21



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